

Date: Wednesday, 6/7/2006 12:02:00 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACER
 Job Number : 27444
 Estimate Number : 10383
 P.O. Number : N/A Part Number : D30661
 This Issue : 6/7/2006 S.O. No. : N/A Drawing Number : D3066 REV. A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 26258 Material : N/A
 Due Date : 6/14/2006 Qty: 40 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06.06.07 W
 Comment : Est:C 02.101 Incorporated D3066-1 IPP KJ/RF

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M5052H32S080

5052-H32 .080 Sheet



Comment: Qty.: 0.0992 sf(s)/Unit Total: 3.9690 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.080" thick

(M5052H32S080)

Batch: M100285

(M6061T6S080.) 6061-T6 .080" THK

2.0

SHEAR

SHEAR



Comment: SHEAR

Cut blank: 16.490" x 0.750" -0.000/+0.010"

N/A

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA280 and Dwg D3065

Stack of 10

Identify as D3066-1

Water Jet
Dry Rev.
Prog Rev.

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

06.06.08 14 (40)

06.06.12 (38)

06.06.15

PTD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-06-12	3	2 parts scrap. holes 1 hole on each part elongated from water jet.	<i>AD</i> 06-06-12	Scrap destroyed.	<i>JL</i> 06-06-12	<i>[Signature]</i> 06-06-12	<i>AD</i> 06-06-12	<i>[Signature]</i> 06-06-12
06-06-14	3	Mat'l .060. Dwg requires .080. Parts not inspected properly. didn't measure mat'l thickness.	<i>AD</i> 06-06-12	Scrap stacks & replace with .080. GOG 1 TG Mat'l	<i>[Signature]</i> 06-06-15	<i>[Signature]</i> 06-06-15	<i>AD</i> 06-06-12	<i>[Signature]</i> 06-06-14

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: *06-06-14*

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/7/2006 12:02:00 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 27444

Part Number: D30661

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr Stack

H.M. 06/06/18
~~06-06-12 38~~

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

26-06-15 (40) ~~06-06-13 38~~

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

SAD 06:06:17 (40) ~~06:06:13 28~~

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB 06/06/20 48
~~06-06-13 38~~

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *WA 18*

06-06-21 40
~~06/06/13 38~~

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/06/21 (40)

Job Completion



06/06/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

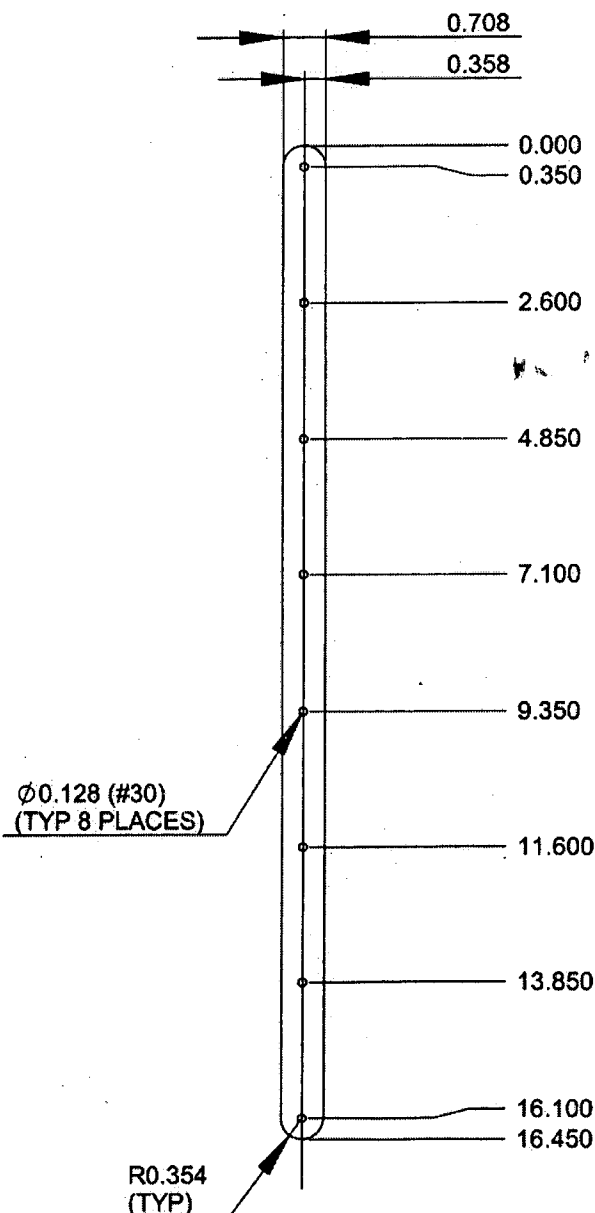
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3066	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE SPACER	SCALE 1:3
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3066-1 SPACER

- 1) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT

NOTICE
WORK ORDER
NO. 27444

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